

Date: Monday, 7/30/2007 1:54:21 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD	
Job Number	33804				
Estimate Number	12784				
P.O. Number	N/A		Part Number	D35649	
This Issue	7/30/2007	S.O. No.	N/A	Drawing Number	D3564 REV C
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision	C
Previous Run	33457		Material	N/A	
Written By			Due Date	8/28/2007	
Checked & Approved By			Qty:	12	
Comment	Est Rev:A New Issue 07-03-08 ec		Um:	Each	
	Est Rev:B As per Rev C 07-07-09 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.9177 sf(s)/Unit Total : 11.0124 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M105136</u> <u>IB 07-07-31</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)**** Dwg Rev: <u>C</u> <u>IB 07-07-31</u> Prog Rev: <u>C</u>		
2-Deburr if necessary <u>09/08/07 fm (12)</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>IB 07-07-31</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>IB 07-08-01 (412)</u>		
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
<u>FF 07-08-08</u>		
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT		
<u>FF 07-08-08</u>		
Form Joggle as per Dwg D3564 on brake using Jig DT		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 33804		Part Number: D35649
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP Ensure joggle as per dwg D3429		<i>Er 07/08/08 x12</i>
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
Qty	Description	Batch
A/R	2059B Hardcoat	<i>M105138</i>
Weld hardcoat as per Dwg D3437		<i>88 07/08/17 x12</i>
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<i>M 07/08/20 (12)</i>
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>M 07/08/20 (12)</i>
10.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		<i>m104846 F 07/08/21 (12)</i>
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>M 07/08/21</i>
12.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>FP-18</i>		<i>BR/MJ 0708-21 (12)</i>
13.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>1 07/08/22 (12)</i>
Job Completion 		<i>U 07/08/22</i>

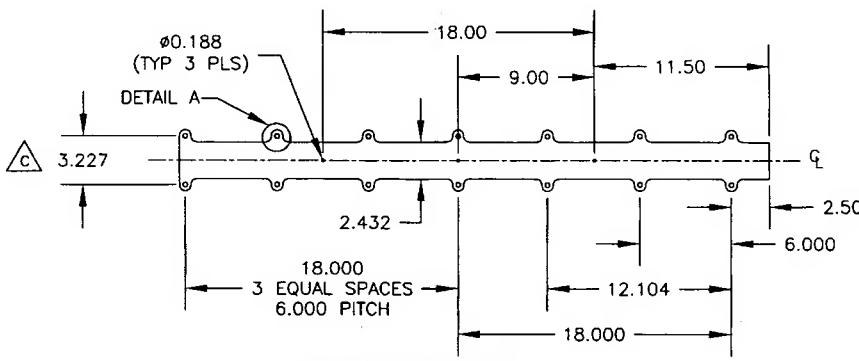
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

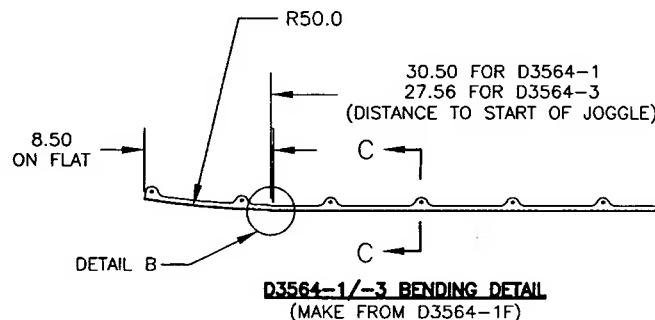
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

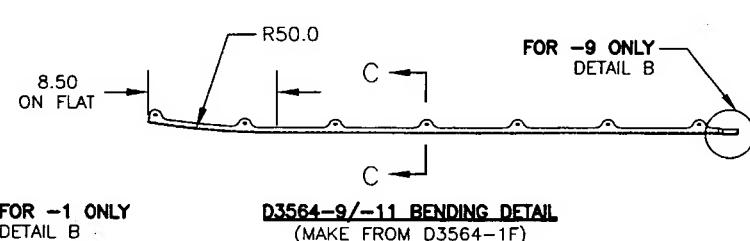
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

D3564-1/-3/-9/-11 WELDING DETAIL

NO. 33804
WORK ORDER
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO

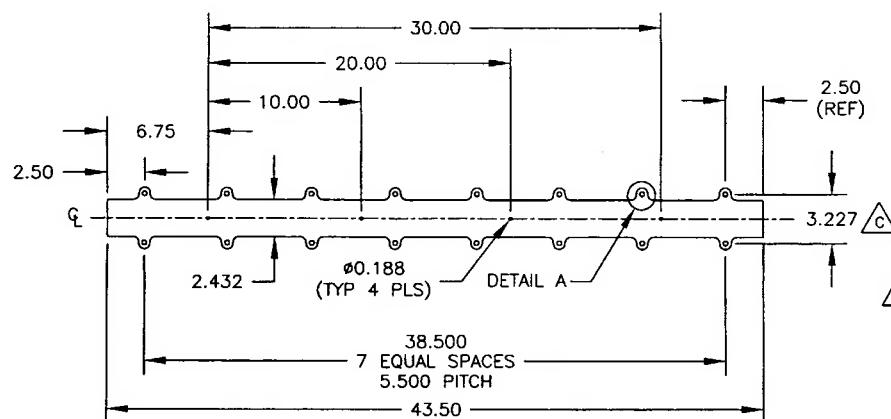
D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

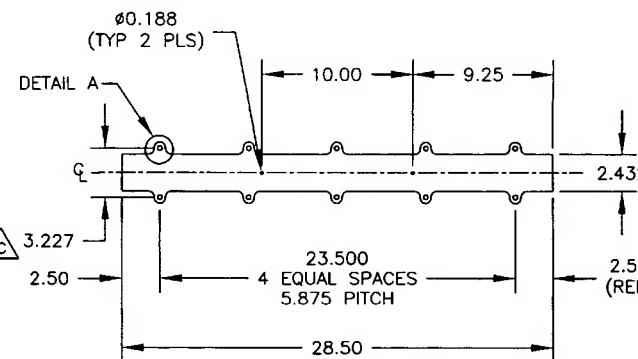
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
<i>PH</i>	<i>PH</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3564
DATE 07.04.17	TITLE WEARSHOE	REV. C SHEET 1 OF 2 SCALE 1:8

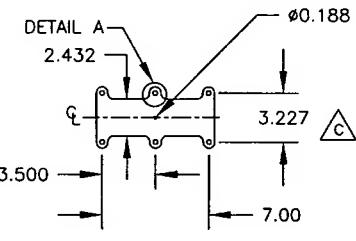
RELEASED
07.06.28 *PH*



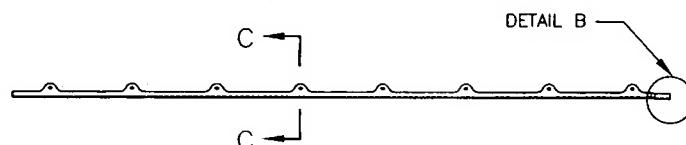
D3564-5F FLAT PATTERN



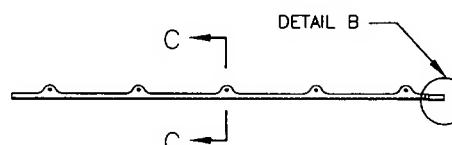
D3564-7F FLAT PATTERN



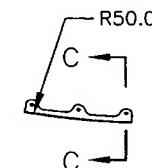
D3564-13F FLAT PATTERN



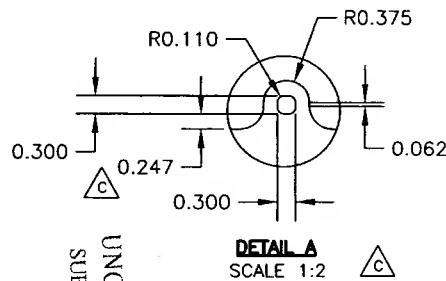
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



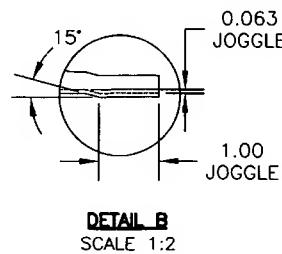
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



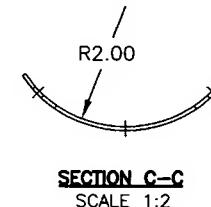
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.06.2017

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DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DRAWING NO.
		D3564
DATE		TITLE
07.04.17		WEARSHOE

DART AEROSPACE LTD.,
HAWKSBURY, ONTARIO, CANADA
REV. C
SHEET 2 OF 2
SCALE 1:8

NO. 33804
WORK ORDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DART AEROSPACE LTD	Work Order:	33804
Description: WEAR PAD	Part Number:	D3564-9
Inspection Dwg: D3564 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	Erj	Prototype Approval:	W/A
Date:	07-07-31	Date:	07/08/01	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	